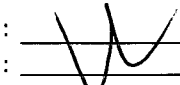


Date: Monday, 19/11/2007 2:24:57 PM  
 Use: Linda Lacelle

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	WEARPAD
<b>Job Number</b> :	35705		
<b>Estimate Number</b> :	10788		
<b>P.O. Number</b> :		<b>Part Number</b> :	D33393
<b>This Issue</b> :	19/11/2007	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3339 REV B
<b>First Issue</b> :	13/11/2007	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	25185	<b>Drawing Revision</b> :	B
		<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	30/11/2007
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	40
<b>Comment</b> :	Est Rev. A New Issue 05-11-10 EC	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M1010S16GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



36945

**Comment:** Qty.: 0.0821 sf(s)/Unit Total : 3.2844 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA) 0.060" thick

Batch: 105706 HB07-12-5

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET

1-Cut as per Dwg D3339

Dwg Rev: B

Prog Rev: B

HB07-12-5

45

2-Deburr if necessary

HB07-12-5

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB07-12-5

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

02/12/05

counts  
45

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE

1-Deburr if necceray

2-Form as per Dwg D3339 using DT8326 and DT8261

SP 07/12/11

45

Date: Monday, 19/11/2007 2:24:57 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 35705

Part Number: D33393

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 5/12/11 (45) counts

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Hard coat 7560 per Dwg D3339, use DT8210 & DT8810 Layout Jig

A/R

7560 Hardcoat

Batch: M106390

Handwritten: FC 08/01/16 (45)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: QCS - 20860118 (45) QC9 ID 08-01-18

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Handwritten: M106442 18 (45x) m-h 08/01/18

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: FC 08/01/18 (45)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 498

Handwritten: 8/1/21 50 (45x)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08-01-21

Job Completion



Handwritten: 2008/1/21

Date: Tuesday, 11/13/2007 1:34:08 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 35705		
Estimate Number	: 10788		
P.O. Number	:	Part Number	: D33393
This Issue	: 11/13/2007 S.O. No. :	Drawing Number	: D3339 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11	Drawing Revision	: B
Previous Run	: 25185	Material	:
Written By	:	Due Date	: 11/30/2007
Checked & Approved By	:	Qty:	40 Um: Each
Comment	: Est Rev:A New Issue 05-11-10 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: Issue P/O: \_\_\_\_\_  
 E-mail or Ship DXF file to vendor  
 Laser cut flat pattern as per Dwg  
 Possible supplier: Ind. Laser  
 Material release note is required.

*W2 Henry*  
*Est done*



2.0	D33393F	WEARPAD-FLAT
-----	---------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)  
 WEARPAD-FLAT



3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached



4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK  
 Inspect as per Template DT8826



5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE



1-Deburr if necceray

2-Form as per Dwg D3339 using DT8326 and DT8261

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:34:08 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 35705

Part Number: D33393

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Hard coat 7560 per Dwg D3339, use DT8210 &amp; DT8810 Layout Jig

A/R 7560 Hardcoat Batch: \_\_\_\_\_

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

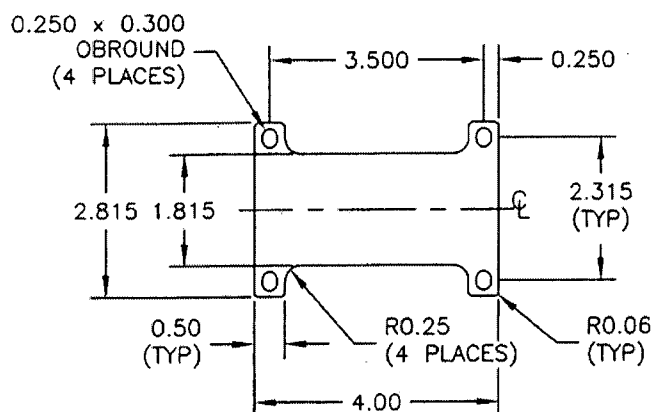
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

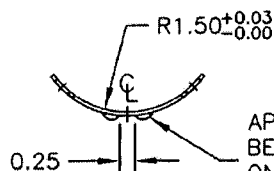


RELEASED  
05.11.22

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. B SHEET 1 OF 3
DATE 05.11.22	TITLE REPLACEMENT WEARPAD		SCALE 1:3
A	05.06.06	NEW ISSUE	
B	05.11.22	CORRECTED HOLE SPACING D3339-7F	



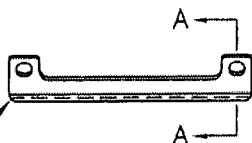
**D3339-1F FLAT PATTERN**



**SECTION A-A**

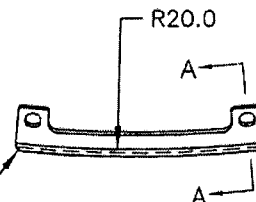
APPLY 7560 HARDCOAT WELD BEADS, 0.063 TO 0.125 THICK, ON BOTTOM SURFACE AFTER FORMING

APPLY 7560 HARDCOAT WELD BEADS PER DT3339-3T1 AFTER FORMING (SEE SECTION A-A)



**D3339-3 CENTER WEARPAD**  
(MADE FROM D3339-1F)

APPLY 7560 HARDCOAT WELD BEADS PER DT3339-5T1 AFTER FORMING (SEE SECTION A-A)



**D3339-5 FORWARD WEARPAD**  
(MADE FROM D3339-1F)

**D3339-1F/-3/-5 WEARPAD**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

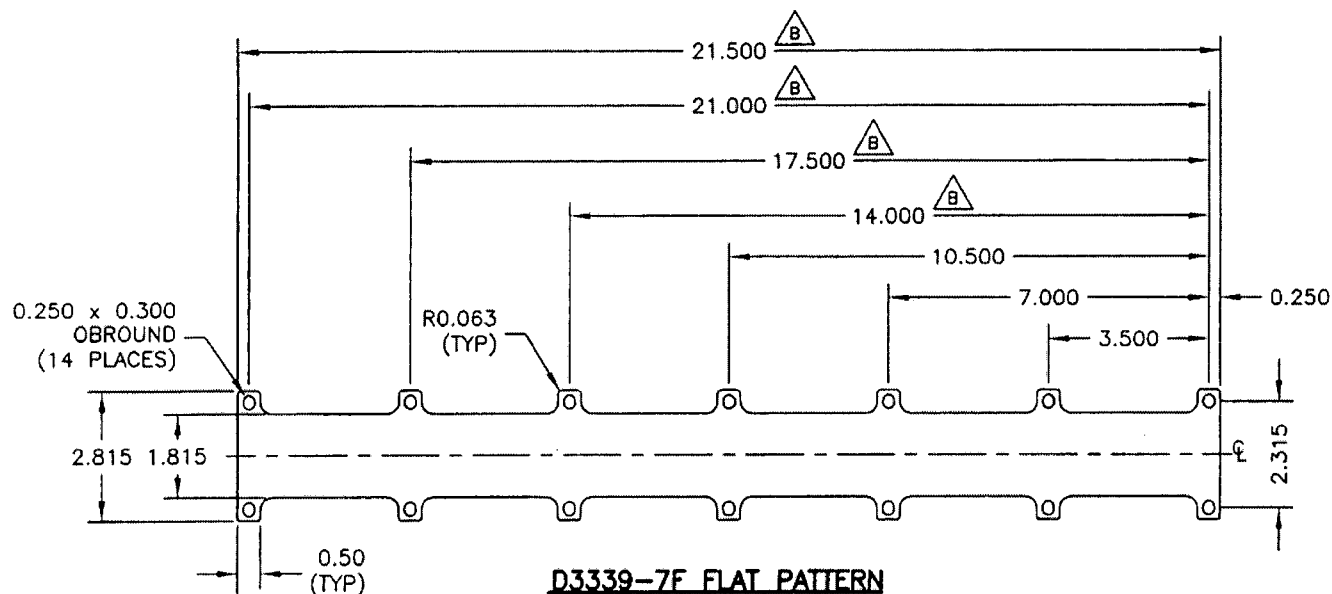
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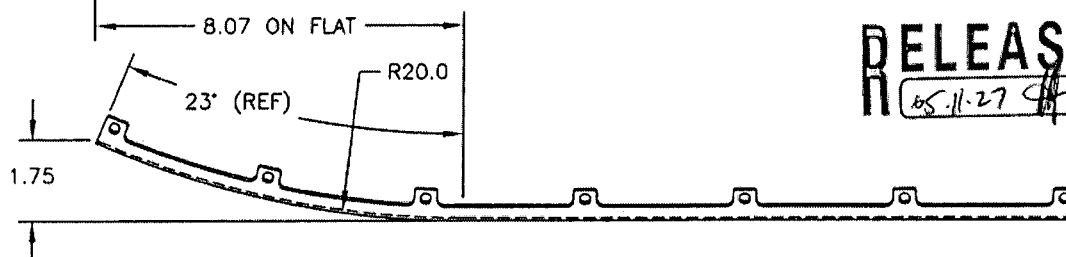
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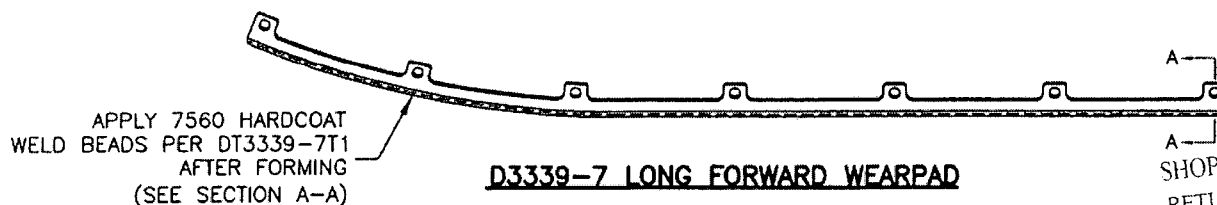
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. B SHEET 2 OF 3
DATE 05.11.22	TITLE REPLACEMENT WEARPAD		SCALE 1:4



**D3339-7F FLAT PATTERN**



**D3339-7B LONGITUDINAL BEND**



**D3339-7 LONG FORWARD WEARPAD**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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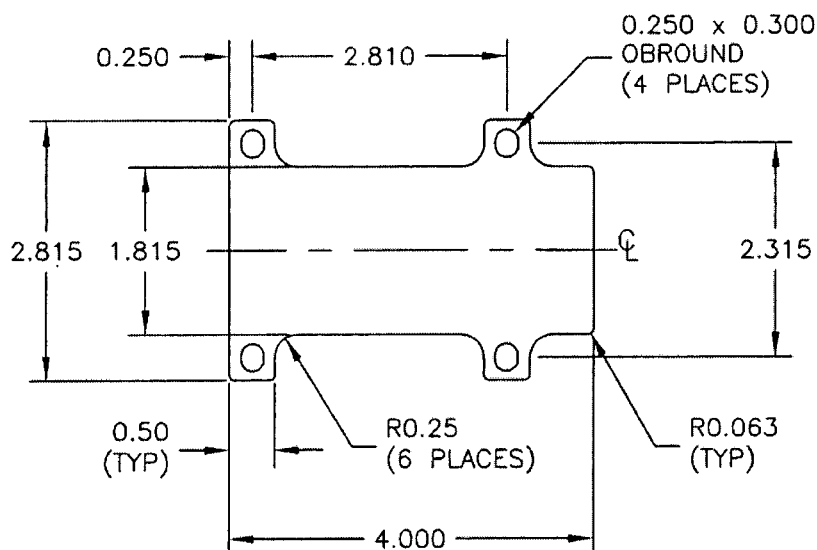
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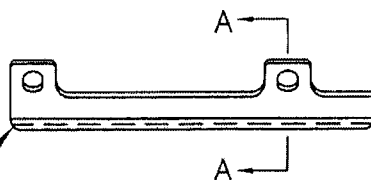
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CHECKED #	APPROVED #	DRAWING NO. D3339	REV. B SHEET 3 OF 3
DATE 05.11.22	TITLE REPLACEMENT WEARPAD		SCALE 1:2



**D3339-9F FLAT PATTERN**

**RELEASED**  
05.11.27 #

APPLY 7560  
HARDCOAT WELD BEADS  
PER DT3339-9T1  
AFTER FORMING  
(SEE SECTION A-A)



**D3339-9 AFT WEARPAD**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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